

Date: Tuesday, 10/06/2008 12:54:27 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HINGE BRACKET		
Job Number	: 39788			Part Number	: D28582		
Estimate Number	: 10349			Drawing Number	: D2858 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 24/06/2008		
Previous Run	: 36856			Qty:	24		
Written By	:			Um:	Each		
Checked & Approved By	:	JUD 08.6.10					
Comment	: Est C 00.06.22 Removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"	
		Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s) Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B15001250) Batch 107461	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 6.02" Note: 1 Blank Makes 3 Parts	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2858-2	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ST 08/07/03 (24)

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

8 N/A

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3 N/A

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

BL 08-07-07 (24)

9.0 POWDER COATING

POWDER COATING



M107925

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

08/07/08 (24)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 51

AS 08/07/08 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/09 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39788
Description: Hinge Bracket	Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

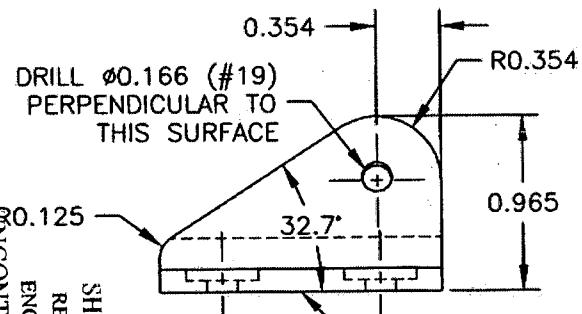
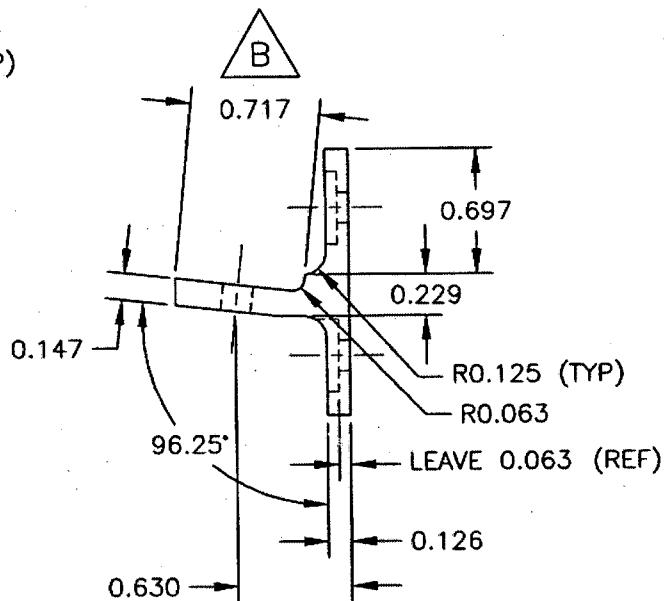
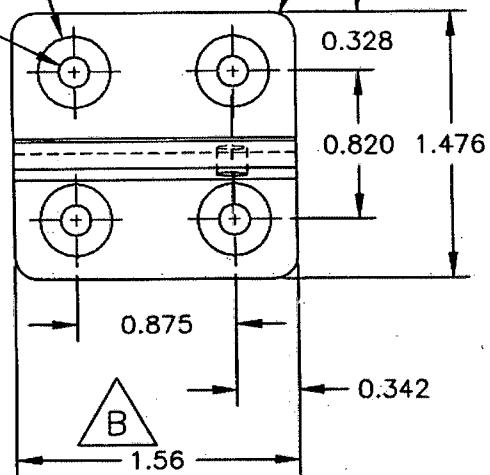
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø.171	/			
Ø0.400	+0.005/-0.000	Ø.400	/			
R0.125	+/-0.010	R.125	/			
.328	+/-0.010	.328	/			
0.820	+/-0.005	820	/			
1.476	+/-0.010	1.480	/			
0.342	+/-0.010	.343	/			
0.875	+/-0.010	.873	/			
1.56	+/-0.030	1.566	/			
0.147	+/-0.010	.147	/			
0.717	+/-0.010	.717	/			
0.697	+/-0.010	.693	/			
0.229	+/-0.010	.223	/			
R0.125	+/-0.010	R.125	/			
R0.063	+/-0.010	R.063	/			
0.063	+/-0.010	.063	/			
0.126	+/-0.010	.126	/			
0.630	+/-0.010	.630	/			
R0.354	+/-0.010	R.350	/			
0.965	+/-0.010	.968	/			
Ø0.166	+0.005/-0.000	Ø.166	/			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/07/03	Date:	08/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM 	

Ø0.400 C'BORE TO
LEAVE 0.063
(TYP 4 PLACES)

Ø0.171
(TYP 4 PLACES)



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 351788

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
99.07.03 KE

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED		APPROVED	DRAWING NO.	REV. B
DATE			D2858	SHEET 1 OF 1
A		98.12.14	NEW ISSUE	
B		99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559	SCALE 1:1